

Work Order ID 73109

Thursday, August 25, 2011 4:03:57 PM



Page 1

Item ID: D206-559-023

Accept



Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 8/26/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: CL Date: 11/08/26 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D206-559	rev L

100	DOCUMENT CONTROL <i>ans</i>	0.00
	DC	0.00
Document Control	Memo	0.00
	Photocopy bluefile and create labels per PPP D206-559-023 CHG007	

W 11 12 01 (2)
for MLS 11-12-1 (2)

160	Pick Kit	0.00
	Packaging	0.00
Packaging	Memo	0.00

SP 11-11-30.

170	QC4- 100% Inspect kits for completeness	0.00
	QC	0.00
Quality Control	Memo	0.00

W 11 12 01 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD206-559-023 Location: _____								
									SP 11-12-01
190 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									
									MF 11-12-01

Lex B.

11/12/11

MF 11-12-01

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Picklist Print

Page 1

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Work Order ID: 73109

Parent Item: D206-559-023

Parent Item Name: Bearpaw



Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: E 04.02.17 Tolerance added to Step 3 KJ/JLM
 IPP Rev: F 07-01-02 Was K10006 JLM
 IPP Rev: G 08-09-19 Added step 2 JLM Verified By: EC
 IPP Rev: H New Manufacturing Method 08-10-29 JLM Verified By: EC
 IPP Rev J 10:10:04 per DSI9527 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-17A

 Bolt

Purchased

No

160

Each

706.0000

12

24

Location

Loc Qty

Loc Code

ST358

300

116419

0

116704

0

117514

200

117619

100

ST359

406

116704

106

118628

300

AN4-20A

 Bolt

Purchased

No

160

Each

560.0000

12

24

Location

Loc Qty

Loc Code

ST359

560

115936

60

116419

200

117514

300

AN960JD416 NAS1149D0463J

 Washer

Purchased

No

160

Each

0.0000

24

48

24X
 M119097 SP
 11-11-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 2

Thursday, August 25, 2011 4:03:54 PM

Work Order ID: 73109

Parent Item: D206-559-023

Parent Item Name: Bearpaw

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 2.00

Required Qty: 2.00

D2182B Manufactured No

160

f

149.5712

2.5

5



Rubber Cushion

Location

Loc Qty

Loc Code

ST410

149.57117

66063

149.57117

(D2182B050) cut qty (6) at 5.00" as per dwg ***per kit***

D2274 Manufactured No

160

Each

712.0000

12

24



Radius Block

Location

Loc Qty

Loc Code

ST010

299

69736

200

69773

99

ST011

413

72121

413

D2438 Manufactured No

160

Each

222.0000

6

12



Clamp

Location

Loc Qty

Loc Code

ST456

222

68673

24

69737

108

70693

90

D2529 Manufactured No

160

Each

421.0000

12

24



Washer

Location

Loc Qty

Loc Code

ST016

421

66953

171

71161

250

B73932 SP

B73389 24x SP.

B73400 SP

SP 11-11-30
24x.

24x.

Thursday, August 25, 2011 4:03:54 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 3

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Work Order ID: 73109

Parent Item: D206-559-023

Parent Item Name: Bearpaw

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 2.00

Required Qty: 2.00

D2672
Bearpaw 13" X 24", 206

Manufactured No

160 Each

0.0000



4

B75326 SP-4X

D2732
Rubber Extrusion

Manufactured No

160 f

582.3981

2.5

5



SP

Location

Loc Qty

Loc Code

ST410

582.39811

64283

83.52811

70987

498.87

(D2732-050) cut qty (6) at 5.00" as per dwg ***per kit***

MS21042L4

Purchased No

160 Each

4,143.000

12

24

Nut

Location

Loc Qty

Loc Code

ST300

4143

117441

57

117601

637

117885

1449

118451

2000

M 119017 SP
24X 11-11-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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D206-559
Page 7 of 13

5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			16	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP

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Revision: L
Date: 11.04.08